

Date: Tuesday, 10/02/2009 3:09:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD FLOOR FOAM
Job Number : 45726	
Estimate Number : 13601	
P.O. Number :	Part Number : D37983
This Issue : 10/02/2009 S.O. No. :	Drawing Number : D3798 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 25/02/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JLD 09-02-10</u>	
Comment : Est Rev:A 08-09-18 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M4111NS125

4111 Black Neoprene/EPDM/SBR Blend Sheet



29.5344* (not enough mat.)



Comment: Qty.: 7.3836 sf(s)/Unit Total : 59.0688 sf(s)

4111 Black Neoprene/EPDM/SBR Blend Sheet

B30632

ml

09 02 24

(4)

2.0

WATER JET

FLOW WATER JET

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3798

Dwg Rev: AProg Rev: A

2-Deburr if necessary

ml

09 02 24

(4)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml

09 02 24



(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK

5 02/02/25 (X4)

5.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: ST 241B

SS 09/02/25 (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD FLOOR FOAM

Job Number: 45726

Part Number: D37983

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/25 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

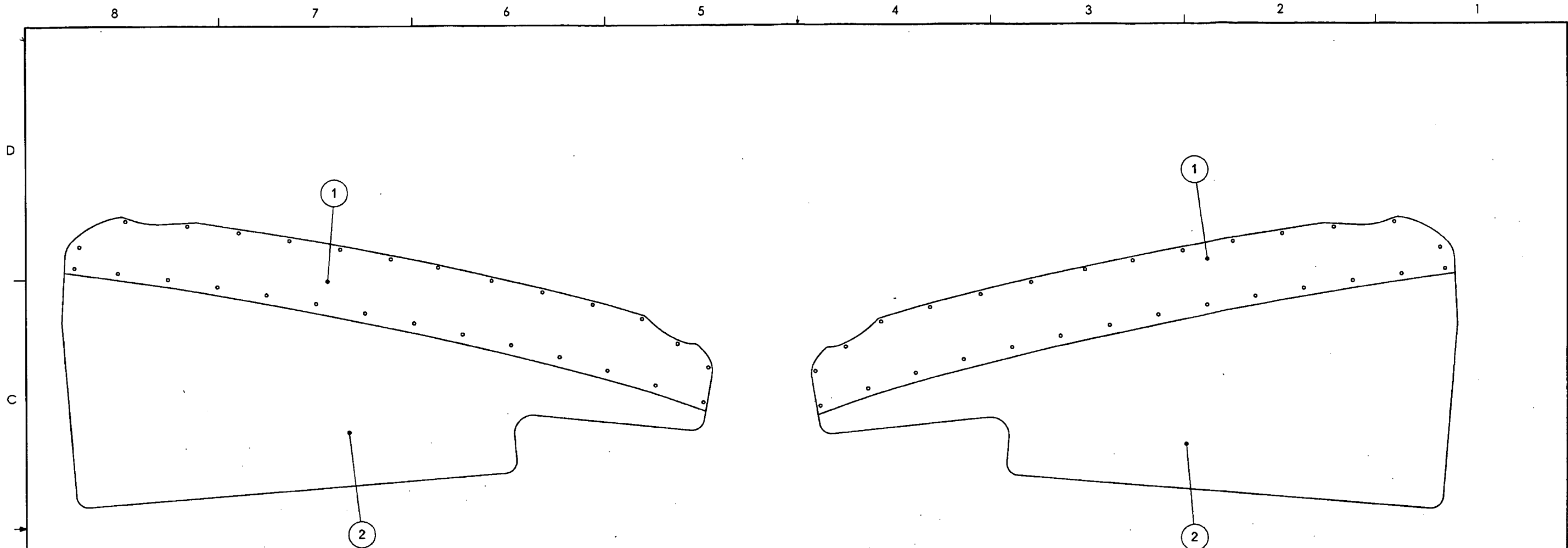
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

x Prototype

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3798-1	SPACEPOD FLOOR	1
2	D3798-3	SPACEPOD FLOOR FOAM	1

D3798-041 SPACEPOD FLOOR, LH

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -042
1	D3798-1	SPACEPOD FLOOR	1
2	D3798-3	SPACEPOD FLOOR FOAM	1

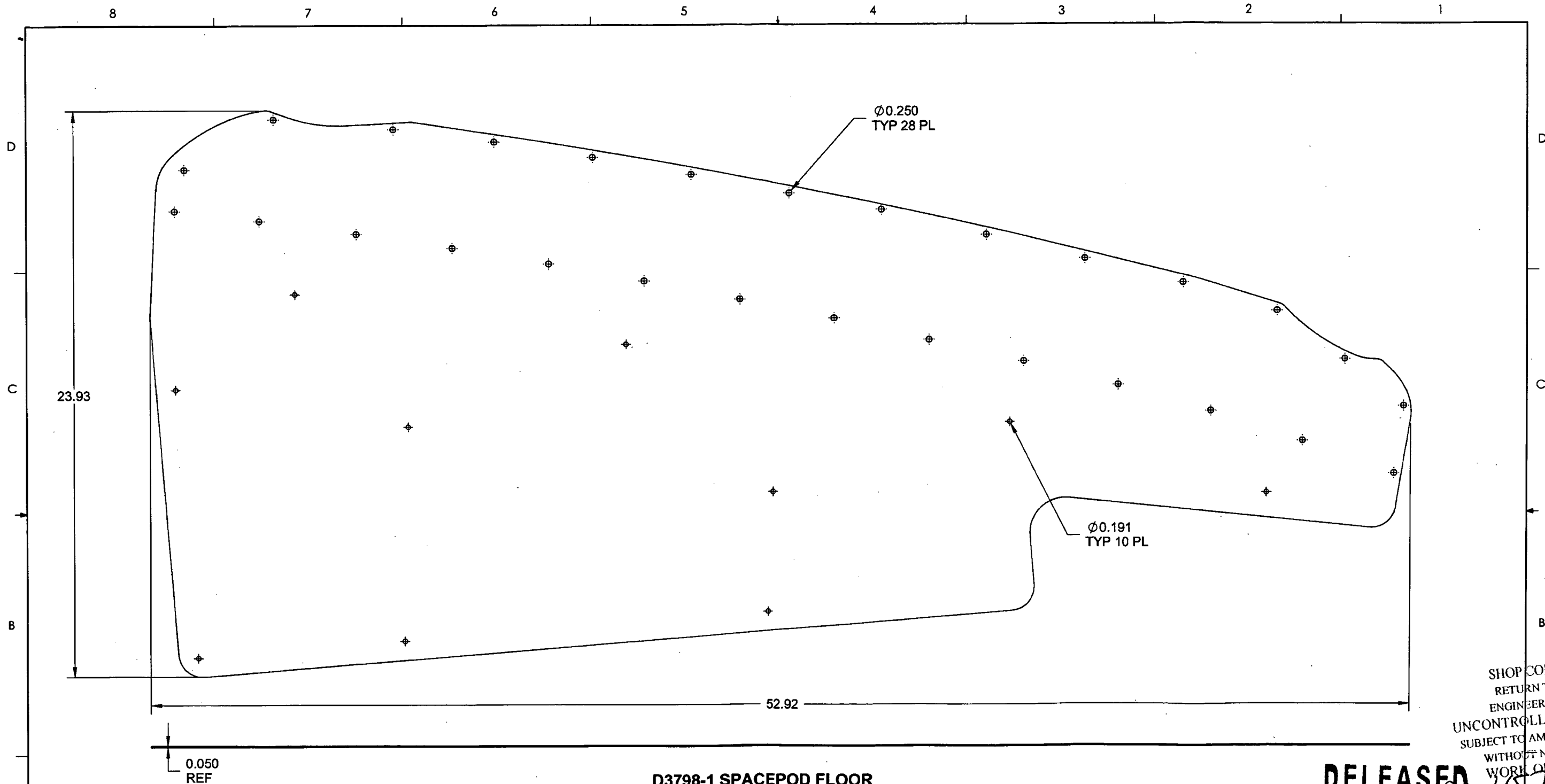
D3798-042 SPACEPOD FLOOR, RH

RELEASED
09/01/13

NOTES:
1) IDENTIFICATION: IDENTIFY WITH DART P/N D3798-041/-042 USING WHITE FINE POINT PERMANENT INK MARKER
2) WEIGHT: D3798-041 - 4.5 lbs
D3798-042 - 4.5 lbs
3) INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT

A	NEW ISSUE	BY	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3798	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	08.10.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NO. 45726



D3798-1 SPACEPOD FLOOR

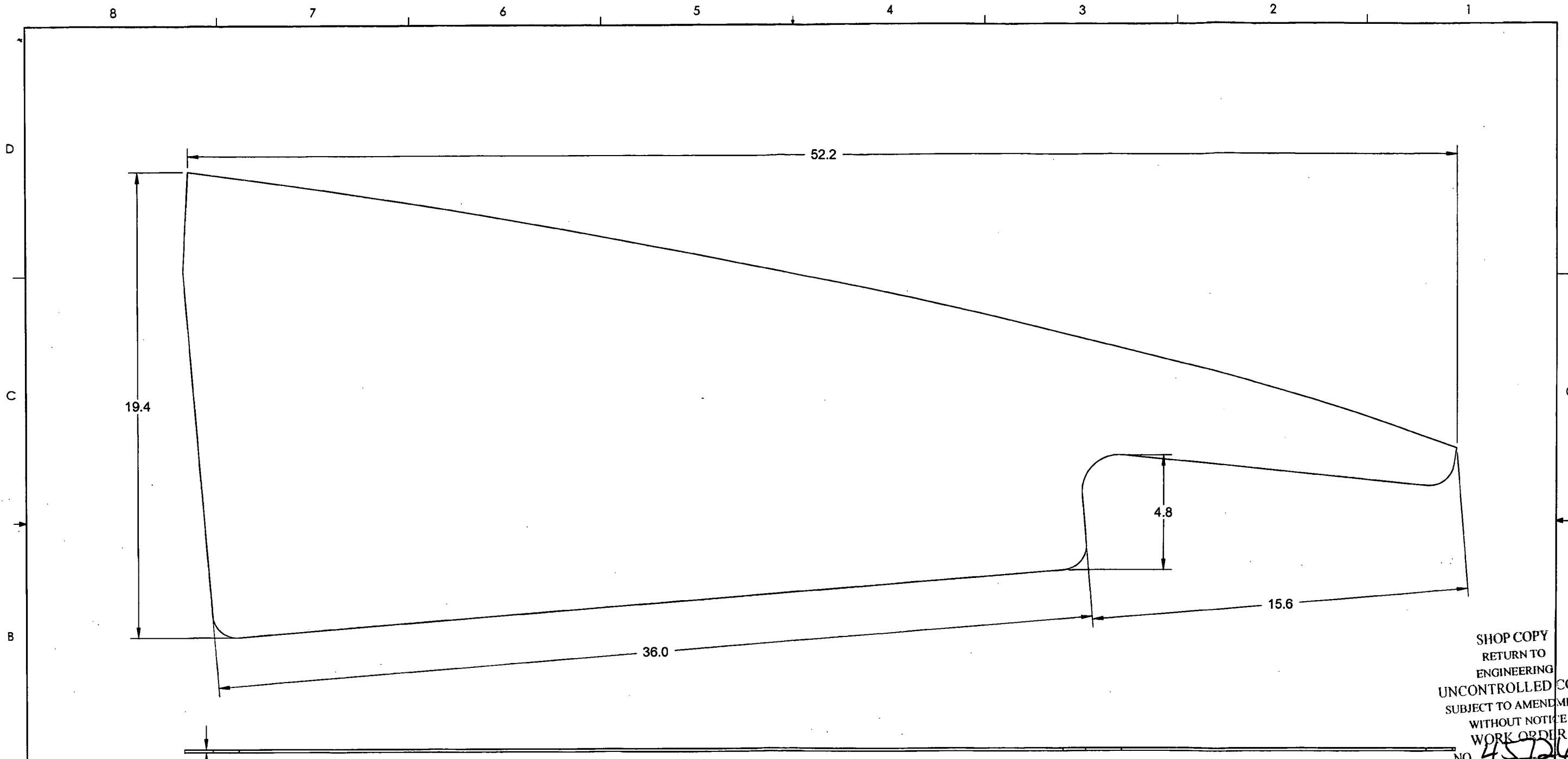
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

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MFG. APPR.		D3798	SHEET 2 OF 3
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DE APPR.		SPACEPOD FLOOR	NTS
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D3798-3 SPACEPOD FLOOR FOAM

RELEASED
 09/01/13

- NOTES:**
 1) MATERIAL: BLACK NEOPRENE CLOSED CELL FOAM, 0.125 THICK (REF DART SPEC M-4111N-S.125)
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.5 lbs
 8) CONTROL PART PER TEMPLATE DT9433

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3798	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
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